

Date: Thursday, 26/02/2009 1:24:09 PM  
 User: Linda Lacelle

## Process Sheet

Customer	: CC-DAR01 Dart Aerospace Ltd.	Drawing Name	: D205-596-103 CUT TO -107 HEIGHT
Job Number	: 46081		
Estimate Number	: 10804		
P.O. Number	:	Part Number	: D205596107
This Issue	: 26/02/2009 S.O. No. :	Drawing Number	: R09-020
Prsht Rev.	: NC	Project Number	:
First Issue	: / / Type : CROSSTUBES	Drawing Revision	:
Previous Run	: 00015	Material	:
Written By	:	Due Date	: 05/03/2009 Qty: 1 Um: Each
Checked & Approved By	:		
Comment	:		

## Additional Product

Job Number:



DC 10 Feb JLD 09/03/03 CHG 002

Seq. #:	Machine Or Operation:	Description :
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1.0	QC5	INSPECT WORK TO CURRENT STEP
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090226 ①



Comment: INSPECT WORK TO CURRENT STEP

1x D205-596-103 original B35428 returned to be cut too 29.8" high, per dwg D205-596-107

2.0	CROSSTUBES	CROSSTUBES RESOURCE 1
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Comment: CROSSTUBES RESOURCE 1

\*\*\* Ensure that the entire surface of the x-tube is protected, so the customers paint does not get damaged.\*\*\*

Mark off cut lines to trim as a -107 @ 29.8".

9-2-27

3.0	QC15	DIMENSIONAL CHECK OF X-TUBES
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Comment: DIMENSIONAL CHECK OF X-TUBES

09.02.27

4.0	CROSSTUBES	CROSSTUBES RESOURCE 1
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Comment: CROSSTUBES RESOURCE 1

-Cut the tube as per dwg D205-596-107.  
 -Debur, and scribe the end of the cuff with the new batch & part number.  
 -Touch up the affected area's with alodine,, and yellow primer as per QSI 005.

9-2-27

5.0	QC5	INSPECT WORK TO CURRENT STEP
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Comment: INSPECT WORK TO CURRENT STEP


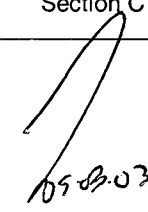

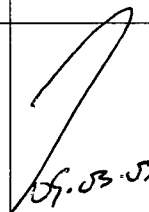
0903-03 ①

# Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: DZ05-596-107 PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes ☒ No ☐ DQA: 1D Date: 09/03/04

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR: <u>46081</u>		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
09.02.27	Z	AT CUT LINES ONE WIDTH 0.2" NARROW, <del>USE</del> OTHER 0.01" WIDE.	 09.02.27 per QSI042	Acceptable	N/A	 09.03.03	 09.02.27 per QSI042	 09.03.03

NOTE: Date & initial all entries

Date: Thursday, 26/02/2009 1:24:09 PM  
User: Linda Lacelle

## Process Sheet

Customer: CC-DAR01 Dart Aerospace Ltd.

Drawing Name: D205-596-103 CUT TO -107 HEIGHT

Job Number: 46081

Part Number: D205596107

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

PACKAGING 1

PACKAGING RESOURCE #1



(10)

Comment: PACKAGING RESOURCE #1

New labels decals and paperwork are required with the new batch #.

Re-package the tube per PPP

Prepare tube for shipment back to the customer.

New ARC required with the new batch # & part #.

9/3/03

SC

7.0

QC4

INSPECT 100% KITS FOR COMPLETENESS



Comment: INSPECT 100% KITS FOR COMPLETENESS

\*\*\*\*INSPECT THE BATCH # AND PAPERWORK.\*\*\*\*

CHG002

509/03/03 x1

(-107)

8.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

09/03/03

Job Completion



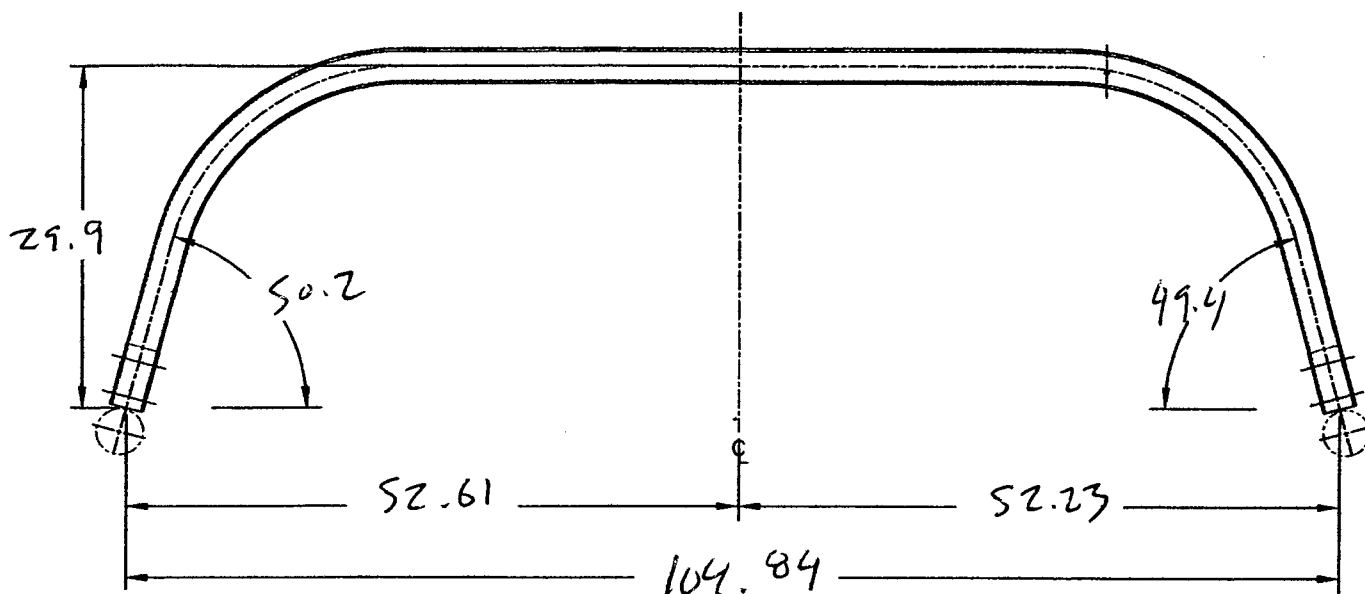
W 09.03.03

<b>DART</b>			
TRANSPORT CANADA APPROVAL # 05-59			
P/N	D205-596-103	CHG	CHG002
DESC	Crosstube Aft Extended	STC	SH03-6
LOT	B35428	STC	SR01742NY
MODEL	205/212	STC	
MADE IN CANADA			

TEL: 1-613-632-3336  
FAX: 1-613-632-4443

DART AEROSPACE LTD		Work Order:	46081
Description: Crosstube High-High Aft		Part Number:	D205-596-107
Inspection Dwg: D205-596-107 Rev: B		Page 1 of 1	

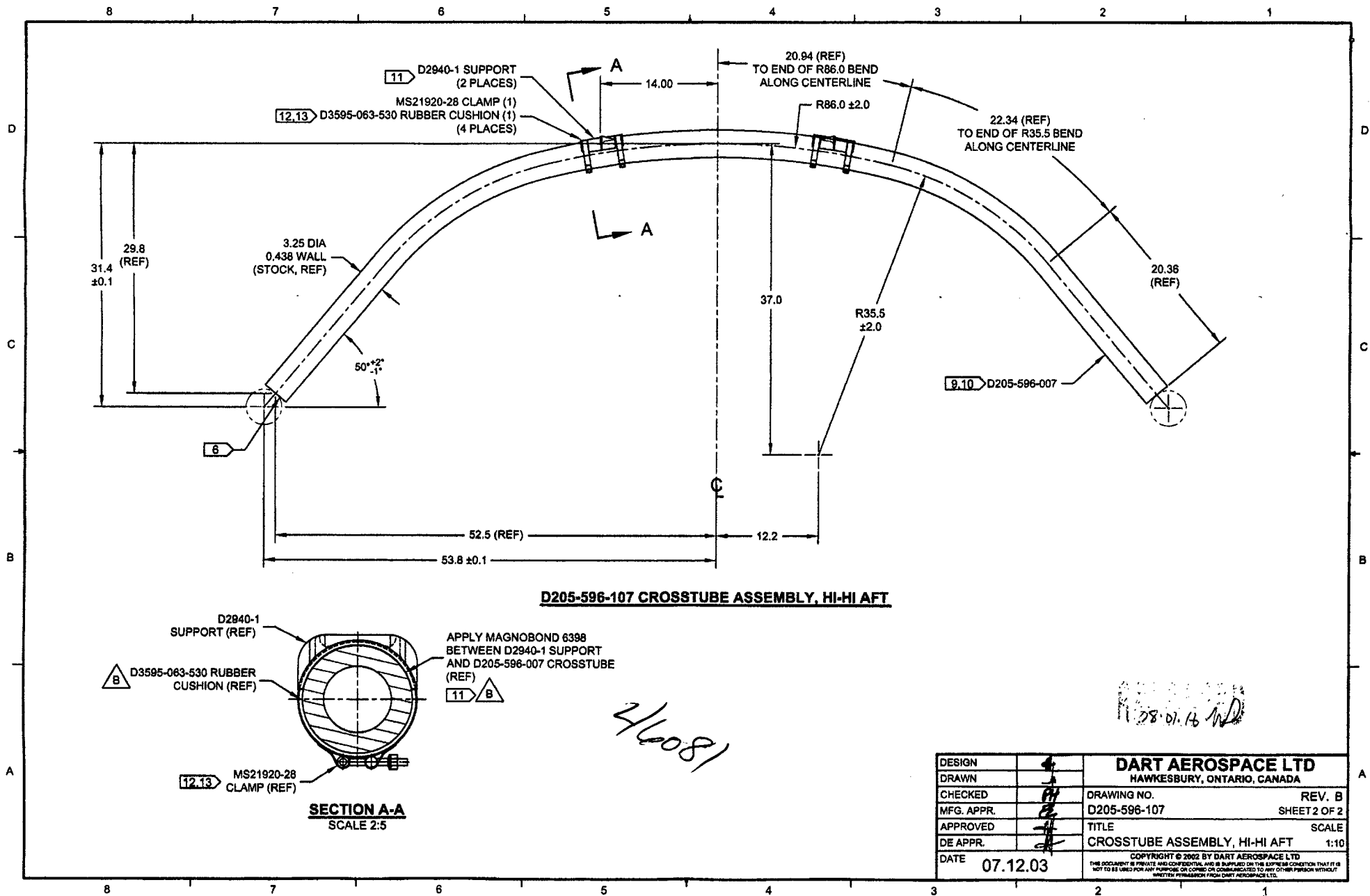
Required Dimension	Min	Max
Height	29.7	29.9
1/2 Span	52.4	52.6
Angle	49	52
Total Span	104.8	105.2



Comments
ONE SIDE NARROW, ONE SIDE TUB WIDF.
Acceptable

QC15 Inspection	69.02.27
Date	

Rev	Date	Change	Revised by	Approved
A	07.02.06	New Issue	KJ/JM	
B	08.04.21	Dwg Rev updated	KJ/JM	



## Jason Murdoch

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**From:** dshepherd@dartaero.com  
**Sent:** February 26, 2009 12:34 PM  
**To:** jmurdoch@dartaero.com  
**Cc:** Peggy  
**Subject:** Fw: RMA528 R09-020

Jason,

Just got cc'd on this by Peggy. You are correct. You need to turn those tubes into -105 and -107. The 31" is just a rough estimate of the height when installed on the aircraft. I recommend getting Chris to inspect the cut locationss before you make the cuts.

David

Sent from my BlackBerry device on the Rogers Wireless Network

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**From:** peggy@darths.com  
**Date:** Thu, 26 Feb 2009 15:17:40 +0000  
**To:** Jason Murdoch<jmurdoch@dartaero.com>; David Shepherd<dshepherd@dartaero.com>  
**Subject:** Re: RMA528 R09-020

Hi Jason -im the wrong person to ask. all I know is the customer has returned 39" as they realized they should have purchased 31" I'm travelling today but back in the office tomorrow

Sent from my BlackBerry device on the Rogers Wireless Network

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**From:** "Jason Murdoch"  
**Date:** Thu, 26 Feb 2009 10:08:10 -0500  
**To:** 'Peggy McDonald'<peggy@darths.com>  
**Subject:** RMA528 R09-020

Good morning Peggy,

I'm creating the custom w/o's for the D205-596 gear to cut as per the customer request to 31", written on the return form.

I just would like to make sure, as to what is needed, because none of our drawings for the D205-596 models are cut TO 31". The only thing I can see is that the D205-596-105 fwd & -107 aft gears are "considered" 31".

Here are the dims of what the original tubes are:

D205-596-101 fwd are 38.3" high

D205-596-103 aft are 37.3" high

Here is what we can cut them to in accordance with our drawings, turning them into:

D205-596-105 fwd at 32.5" high

D205-596-107 aft at 29.8" high

Is this correct?

26/02/2009

Jason Murdoch  
**Qc. Coordinator**  
jmurdoch@dartaero.com

***"We provide solutions"***

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26/02/2009